

SPLIT

Date: Monday, 10/22/2007 10:34:31 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 35262	
Estimate Number : 12576	
P.O. Number :	Part Number : D3562041
This Issue : 10/22/2007 S.O. No. :	Drawing Number : D3562 UNDER REVIEW OK PER REV. C
Prsht Rev. : NC	Project Number : N/A 07.10.22 DC
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 34269	Material :
Written By :	Due Date : 11/10/2007 Qty: 5 Um: Each
Checked & Approved By : <i>10 07.10.22</i>	
Comment : Est Rev A New Issue 06-11-09 JLM	
Est rev B ECN 987 07.10.09 EC verified by: DD	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>B.34016</i>

Check Material for any Dents or Defects

11.06 5

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

11.06 5

11.06 5

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.06

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 07-11-06 (5)



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35262

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description:

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m. 07.11.22 5

6.0

D3560041

ARM WELDMENT

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
ARM WELDMENT R35039

a.m. 07.11.22 5

7.0

D3560043

ARM WELDMENT

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
ARM WELDMENT
Batch: R35031

a.m. 07.11.22 5

8.0

MS20600AD4W5

Blind Rivet

Comment: Qty.: 36.0000 Each(s)/Unit Total: 180.0000 Each(s)
Blind Rivet
batch: M106074 12/M105953

a.m. 07.11.22 5

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Transfer drill Rivet holes as per dwg D3562.
- 2-Touch-up rivet holes with alodine as per dwg d3562
- 3-Rivet legs using Magnabond as per dwg D3562.
- *****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398

Batch: M105379

a.m. 07.11.22 5

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

a.m. 07.11.22 (41)

11.0

D2734

206 Step Endplate

Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Pick:
Qty Part Number Description Batch

a.m. 07.11.22 1

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Drawing Name: STEP WELDMENT

Job Number: 35262

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2734

End Cap 334485

10-11-22

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

10-11-22

2-Grind end cap welds flush as per Dwg D3562

10-11-22

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10-11-23

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/11/23

15.0

POWDER COATING

POWDER COATING



M105914



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07/11/23

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M106030

BR/

07-11-23

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-11-23

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

35956

7/11/23

SP (1X)

Date: Monday, 10/22/2007 10:34:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STCP WELDMENT

Job Number: 35262

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

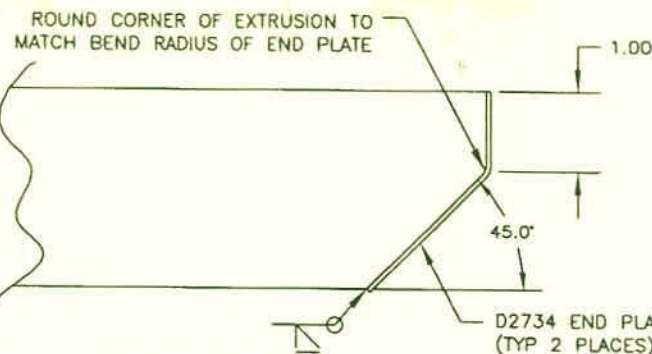
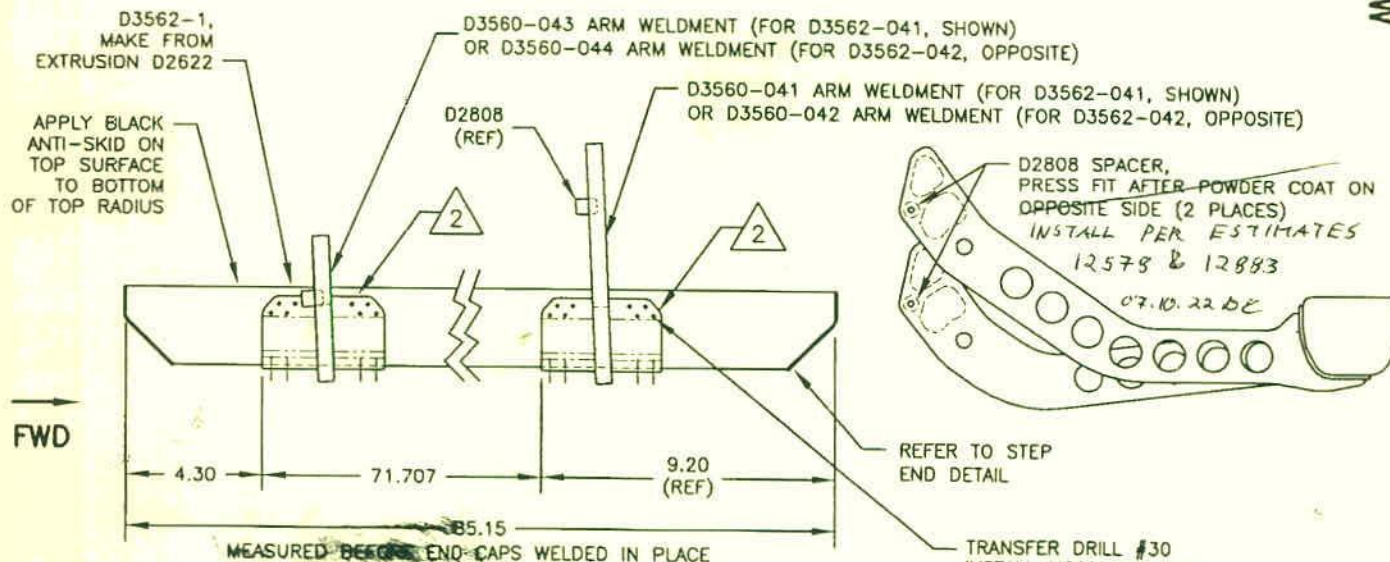


11-07-23

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DART**RELEASED**
07.06.22 DE**UNDER REVIEW**07.10.22 DE
OK PER REV. C

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

**TYPICAL STEP END DETAIL**
NOT TO SCALESHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35262**D3562-041 LH STEP ASSEMBLY (SHOWN)**
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	CP	D3562
DATE	TITLE	REV. C
07.06.19	STEP ASSEMBLY	SHEET 1 OF 1
		SCALE
		NTS
A	06.09.26	NEW ISSUE
B	07.01.15	ARMS NOW RIVETED TO STEP
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTS

